Work Order ID 60387

July 7, 2010 9:01:39 AM



Page 1

Item	ID.
TICILI	ш,

D6104-005

Accept



Setup Start

Stop



Revision ID:

Item Name: Round Billet, 17-4

Start Date:

7/07/10 Required Date: 7/22/10 **Start Qty: 10.00**

Req'd Qty: 10.00



Cust Item ID:

Customer:

Reference: Approvals:

Process Plan:

Date: $\frac{10}{7}$ Tooling:

Date:____

SPC (Y/N):

Date:

Date:

Run Start

Stop



Sequence ID/ Work Center ID

Draw Nbr

Operation Description

Revision Nbr

Rev B

Set Up/

Run Hours

Tool ID

Tool # Plan Code

Qty

Accept Reject Qty

Reject Number Stamp

Insp.

D6104

100

PURCHASING

Memo

0.00

0.00

CZ 10/7/8

Purchasing Purchasing

Issue P/O: 12218 $_$ \Box a)Description: S.S round,billet \Box b) \emptyset 4.00" x 5.10" long c) Tolerance on all dimensions are +0.030"/-0.000" d) Material: 17-4PH Stainless steel (Ams 5643 or Aisi 630)□e)One blank makes 2 parts□f) Material certification required

110

Packaging

Receive & Inspect for Damage & Mat'l Certs

0.00

0.00

Packaging

Ensure material certification is attached

120

QC6- Inspect dimensions to drawing

Memo

0.00

Quality Control

Ensure Material certification comply to Dwg D6104

ank10/07/22

						•			
Dart Ae	rospace	Ltd				-			
W/O:		~ 1 .		WO	RK ORDER CHANG	ES			
DATE	STEP		PR	OCEDURE CHAN	NGE	Ву	Date Qty	Approval Chief Eng / Prod Mgr	Approva QC Inspecto
					, , , , , , , , , , , , , , , , , , , ,				
		- To a							,
Part No	:		PAR #:	Fault Categ	jory:	_ NCR: Yes	No DQA :	Date: _	**
	Re	esolution:		Disposition):	_ QA: N/C CI	osed:	Date: _	
NCR:				WORK ORDE	R NON-CONFORMA	ANCE (NCF	R)		'
5475	0755	eten Description of NC			Corrective Action Section	ion B	Verification	Approval	Approva
DATE	STEP		Section A	Initial Chief Eng	Action Description Chief Eng	Sign 8 Date	Section C	Chief Eng	QC Inspecto
					•				

NOTE: Date & initial all entrie

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE

Work Order ID 60387

July 7, 2010 9:01:39 AM



Page 2

Item ID:

D6104-005

Accept

Setup Start

Stop



Revision ID: Item Name:

Round Billet, 17-4

Start Date:

Required Date: 7/22/10

7/07/10

Start Qty: 10.00

Req'd Qty: 10.00

Cust Item ID:

Customer:

Reference: Approvals:

Process Plan: _____ Date: ____

Tooling:

Date:

Start

Run

QC:

Date: _____

SPC (Y/N):

Date:

Tool # Plan

Code

Stop

Reject

Qty

Sequence ID/ Work Center ID

130



Packaging

Packaging

Operation Description

Identify as per dwg & Stock Location:

Set Up/ **Run Hours**

0.00

Tool ID

Qty

Accept

Reject Insp. Number Stamp

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

Memo

0.00

Dart Ae	rospace Lt	d										
W/O:				WO	RK ORDER CHANG	ES						
DATE	STEP		PR	PROCEDURE CHANGE					Approval Chief Eng / Prod Mgr	Approva QC Inspector		
Part No):		PAR #:	Fault Cated	jory:	NCR: Yes No DQA: Date:						
	Resolution:			Disposition	1:	_ QA: N/C CI	osed:		Date: _			
NCR:				WORK ORDE	R NON-CONFORMA	NCE (NCF	R)					
	CTED Description of NC		scription of NC		Corrective Action Section	on B	Verification		Approval	Approval		
DATE	STEP		Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section		Chief Eng	QC Inspecto		
	1											

NOTE: Date & initial all entries

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE

Picklist Print

July 7, 2010 9:01:38 AM

Work Order ID: 60387

Parent Item: D6104-005

Parent Item Name: Round Billet, 17-4



Start Date: 7/07/10

Required Date: 7/22/10

Comments:

Comments:	IPP A: □01.05.08	B□New Issue B	CC						Start Qty: 10.0	00		ed Qty: 10.00
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	- .	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total	Qty	Date Status
17-4 SS Roundbar 4.00"OD	III 1 111 11111 11111	Purchased	No			110	Each			Qty 10	Issued	Issued

	•										
Dart Ae	rospace	Ltd									
W/O:				WC	ORK ORDER CH	IANGES					
DATE	STEP		PRO	OCEDURE CHANGE			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approva QC Inspecto
					· 						
Part No):		PAR #:	Fault Cate	gory:	NC	R: Yes	No DG	A:	Date: _	
	Re	solution:		Disposition:			QA: N/C Closed: Date:				
NCR:	-			WORK ORD	ER NON-CONFO	ORMANCI	E (NCF	₹)			
DATE	STEP	D	escription of NC Section A	Initial	Corrective Action Action Descri	Section B ption	Sign	& Sec	ication tion C	Approval Chief Eng	Approva QC Inspect
				Chief Eng	Chief Eng		Date	!			

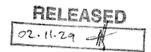
NOTE: Date & initial all entres

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE

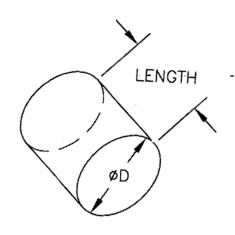




DESIGN + T	DRAWN BY	DART AEROSPACE LTD
DATE 02.11.25	APPROVED	DRAWING NO. D6104 TITLE Rev. I
A	01.04.1ป	ROUND BILLET, 17-4 NTS
В	02.11.25	CLARIFY ALLOY SPEC ADDED D6104-009/-011 REDUCE LENGTH OF BILLETS



SPECIFICATION CONTROL DRAWING



MATERIAL: 17-4 PH SS (AMS 5643 OR AISI 630) MIN UTS = 170 KSI (38 HRc)

PURCHASE MATERIAL ACCORDING TO THE FOLLOWING TABLE. SPECIFY ALLOY, DIAMETER X

TOLERANCE ON ALL DIMENSIONS IS +0.030/-0.000.

ALL DIMENSIONS ARE IN INCHES

Part No.	Alloy		
D6104-001		D (Diameter)	Length
D6104-003	17-4 PH STAINLESS STEEL 17-4 PH STAINLESS STEEL	Ø3.00	3.80
D6104-005	17-4 PH STAINLESS STEEL	Ø3.25	3.80
D6104-007	17-4 PH STAINLESS STEEL	Ø4.00	5.10
D6104-009 D6104-011	17-4 PH STAINLESS STEEL	Ø4.50 Ø5.25	5.10
D0104-011	17-4 PH STAINLESS STEEL	Ø6.50	4.10 4.10

SHOP COPY RETURN TO **ENGINEERING** UNCONTROLLED COPY

SUBJECT TO AMENDMENT WITHOUT NOTICE WORK ORDER NO 60382

CZ1017/7

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Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K6A 1K7 Tel: 613 632 9577

Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO12218

Purchase Order Date 7/08/10 PO Print Date 7/08/10

Page Number 1 of 1

Order From:

METAUX CASTLE

VC-MET001

A.M. CASTLE & CO. (CANADA) INC. - BOX B9204 PO BOX 9100 TORONTO, ON M4Y 3A5

CA

Contact Name

Vendor Phone

Vendor Account Nbr

514 694 9575

Vendor Fax

514 695 3281

Buyer

Chantal Lavoie

Requisition Nbr Tax Resale Nbr

10127-2607 Net 30

Terms Currency

CAD

FOB

Ship To:

DART AEROSPACE LTD

1270 ABERDEEN HAWKESBURY, ON K6A 1K7 CANADA

	Revision ID	Description/ Mfg ID	Req Date/	Req Qty/	Ship Method	Unit Price	
_	Vendor Part Number 6104-005P	17-4 SS Roundbar 4.00"OD	Taxable Unit	of Measure		ome i rice	Extended Price
			7/23/10 Yes	10.00 Each	Yours ppd	\$78.0000	\$780.00

Special Inst:

AS PER DWG D6104 REV.B B60387

MATERIAL: 17-4 PH AS PER AMS 5643 OR AISI 630

TOLERANCE ON ALL DIMENSION ARE

+0.030"/-0.000"

SIZE: 4.00" X 5.10" LONG

PO Total:

\$780.00

MATERIAL CERTIFICATION REQ'D UPON DELIVERY

Change Date: 7/08/10 No substitution or deviation without consent.

Certificate of Conformity or Material Certification required when applicable

Change Nbr:



A. M. Castle & Co.

PACKING SLIP

Page 1 of 1

Ship From:		Sold To:		Ch:
Castle Metals MONTREAL 835-SELKIRK AVEN POINTE CLAIRE, QU H9R 3S2	IUE UEBEC	DART AEROSPACE LTD 1270 ABERDEEN HAWKESBURY, ON K6A 1K7	Ship To: DART AEROSPACE LTD 1270 ABERDEEN HAWKESBURY, ON K6A 1K7	Shipment No:419777 Deliver To: DART AEROSPACE LTD 1270 ABERDEEN HAWKESBURY, ON K6A 1K7 CA
Date Shipped 21-JUL-10 Shipment Details	F.O.B. ORIGIN	Freight Terms Prepaid	Carrier LOCAL_FLEET	BOL No 419777-3

Order No	lima N		Final	Destination	Branch - MON		
857140	Line No	Item No	Desc	ription			
007450	1	42464.MO	4.000	ODDATOR			, , , , , , , , , , , , , , , , , , ,
	•		4.000	U.RD.17CR-	4NI.STAINLESS	S.RT.SOL TR C	COND
			1		U(X)		
			CUT	ΓO 5.1 IN (+	1250/0000 II	VI) - BAND CA	MOUTTING
						EEVS VOVE O	WCUITING
Purchase Order	No Pa	rt Number	A564,	UNS S17400)	JU43,ASIVIE S	A564,ASTM
2218	VC	NID ITEMANUS	Order	ed Qty		- 1	
	100	OUR ITEM NUMBER:	10 PC		t	Invoice Q	ty
etails	1 00	104-005		J		10 PCS	
elivery No.	NA:t1				! 		<u> </u>
····· , 140,	Mill	Heat Number	Mech Id	DOG	, ,		
	1	423013	- incomia	PCS	Width (IN)	Length (IN)	Shipped Qty (LBS
34620303				I 10			

These commodities/technologies are subject to US Export Administration & US State Dept. Regulations and, if intended for export, were/are exported thereunder. Diversion contrary to US Law is Prohibited.

We hereby certify the material covered by this certification conforms in accordance with the above specifications and has been found to meet the applicable requirements for the material, including any specifications forming a part of the description. For credit, and the conformal c

Ont 10/01/22

PO 62960-30

Report
5900 IC H2464

VALBRUNA

SLATER STAINLESS, INC. 2400 Taylor Street West, P.O. Box 630 Fort Wayne, Indiana USA 46801 Phone: 280-434-2892 Fax: 260-434-200

Dennis Hackett

Product Certification Report

Report Number: 4535900

1000963 005	Order De	100	modity Code	1								
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4.0000	.0000	.000		013 0024		26918	nebiO ess				··· ··································	\neg
Product Shape		Produc	Surface	020 000	.,2	20310			Tree	letomer Grade		
Rounds Length (Inches)		HR	& Rou	gh Turne	d				- 1	30 30		
				Bill of Lading #	Weight				10.	30		
132.000	Min. I	56.000	Max.	411913	<u> </u>							}
Chi. 370 VII	NA STAIN LLAGE DE STREAM,	STVR			Sold To	370 V	/ILLA	GE D	RIVE	60188		
Lifts: 0046				· · · · · · · · · · · · · · · · · · ·								
API 6A			AISI 1	7400			ENT	1000	, , ,			
UNS S17400								1020	4 3.1			
AMS 5643R (exc SMESA-564-07	ept finis	h)	ASTMA .	564-04 Ty	pe 630		AS	TM A4	84-08			
CHEMICAL ANA		· · · · · · · · · · · · · · · · · · ·										
C Mn	Р Птото	s :	Si	C+			_					
.04 .59	.023	.022	41 11	Cr 1 5.68 4,6		Mo (18 3.3	Cu	N	Cb		Cb+Ta	
RINELL HARD	NESS AST	TM E10-	0.8	2.00 -4.0	20	10 3.	3/	.04	.23	.001	23_	
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HBW 358												
HBW 358 ENSILE PROP												
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HBW 358 PENSILE PROPI CAPABILITY Cap HB TS 400	BRTIES 2 (PSI) 205000	ASTM E8 .2%YS (E	-08 PSI)				-	···	·		***************************************	
HBW 358 PENSILE PROPERTY CAP HB TS 400 AGNETIC PART	BRTIES 2 (PSI) 205000	ASTM E8 .2%YS (E	-08 PSI)	%EL(4d) 15.8			-		,			
HBW 358 PENSILE PROPICATION CAP HB TS 400 LAGNETIC PART FREQ SEV	BRTIES 2 (PSI) 205000	ASTM E8 .2%YS (E	-08 PSI)				-					
HBW 358 PENSILE PROPI APABILITY Cap HB TS 400 AGNETIC PART FREQ SEV VG .04 .02	BRTIES A (PSI) 205000 FICLE TE	ASTM E8 .2%YS (1 183	-08 PSI)				-	-				
HBW 358 PENSILE PROPI APABILITY Cap HB TS 400 AGNETIC PART FREQ SEV VG .04 .02 ACRO ASTM E3	BRTIES A (PSI) 205000 FICLE TE	ASTM E8 .2%YS (1 183	-08 PSI)			90	00					
HBW 358 ENSILE PROPI APABILITY Cap HB TS 400 AGNETIC PART FREQ SEV VG .04 .02 ACRO ASTM E3 MACRO	BRTIES A (PSI) 205000 FICLE TE	ASTM E8 .2%YS (1 183	-08 PSI)			90	00	7				
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VALBRUNA

SLATER STAINLESS, INC. 2400 Taylor Street West, P.O. Box 630 Fort Wayne, Indiana USA 46801 Phone: 260-434-2892 Fax: 260-434-2806

Product Certification Report

Report Number: 4535900

		. H40-404-2002 F8X: 2	260-43 <i>4</i> -290x				
	Order (.0.	Order Date	Commodity Code	Certified on Ap	r 28, 2010	Page 2 of	
	1000963 005	01-0	6304.0RT			Page 2 of	
	4.0000	Dir.	n 3 Heat I.D.		Se Order		
	Product Shape		0000 42301 Product Surface	3 002472 26918			
,	Rounds Length (Inches)	•	IR & Rough	Marson - 2		Customer Grade	
	1 /			of Leding # Weight		630	
	132.000 M	in. 156.00		111913		<u> </u>	\dashv
	VALBRUN	A STAINLESS					_
	Treatment of the Article	LAGK DRTNE	Y TWG	VALBR	UNA STAINLE	ESS TNO	
	To CAROL ST	TREAM, IL.	60188		TUDALIK INDTY	77	
				To CAROL	STREAM, IL	60188	
				I			
I G	Material conforms	to listed specific	ations and is T	FADQ complicati			
Ì	thatity system is co	ompliant with Is	SO 9001:2000.	PFARS compliant. Produced in accordance	ww.141. T73 7 4 6 6 6 .		
1				woodtoauce	WITH BN 10204	3.1	
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		16/pm	/				
		Onl	? c				
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Castle Metals FP 4230/3 HEAT NUMBER MECHANICAL ID ITEM CODE LOT NUMBER PO NUMBER RECEIPT DATE SUPPLIFE SPECIFICATION LCS COMMENT **APPROVED**

Results relate only to the items tested. Certification shall not be reproduced except in full, without written approval of Valbruna Stainless Inc. The recording of false, fictitious, or fraudulent statements on this document may be punished as a felony under federal statutes; including Federal law, Title 18, Chapter 47. Consult material safety data sheet (MSDS) for hazard info. I hereby certify that the reported figures are correct as contained in the records of the corporation.

Manager Laboratory Services

Dennis Hackett